



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

14 Dec
D212-725-1-247
Job Sheet 185813



Sold Alone

Part No: D212-725-1-247

Job Qty: *2 pcs*

*DAS
21
9-89*

Part Name: Cam Half



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4163 REV.A IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	2 pcs		12/13/18	0.00	0.67	HAAS - 1 - B4B		<i>DAS 52 18/11/16</i>
110	QC 2	2 pcs		12/13/18	0.00	0.00	QC 2 - 1		<i>9-89 18/11/16</i>
120	QC 8	2 pcs		12/13/18	0.00	0.00	QC 8 - 12		<i>18/11/18</i>
130	Handfinish - 1-1 Chemical-B4B	2 pcs		12/13/18	0.00	0.20	Handfinish - 1 - 1 - B4B		<i>DR 18/11/19</i>
140	QC 7	2 pcs		12/13/18	0.00	0.00	QC 7 - 10		<i>38 9-89</i>
150	Packaging 3-1 - Stock - B4B	2 pcs		12/13/18	0.00	0.00	Packaging 3 - 1 - B4B	<i>5/17/18</i>	<i>NOV 21 2018</i>
160	QC 21 - SA	2 pcs		12/13/18	0.00	0.00	QC 21 - SA - 16		<i>21 9-89 NOV 21 2018</i>

Part Op 100 - Cut blanks 3.250" long Machine as per folio FA843 and DWG Folio rev: *AA* Dwg Rev: *A*
Descriptions: Deburr as per Dwg

110 - Inspect parts off machine FAI/FAIB

120 - Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - Inspect Chemical Conversion Coat

150 - Identify as per dwg and stock. Location: _____

160 - Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.625X02.500	6061-T6 Bar .625 X 2.50	.6000 ft (.3 ea)	100-HAAS 4 Axis	<i>FM134553 5129412</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	M6061T6B0.625X02.500	1	5	0

Part Specifications

Specifications could not be found.

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐												
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐												
Finishing ☐	Rec/Store/Packaging ☐	Other ☐												
Composite ☐	Supplier ☐													
		MRB (QSI042) Approval												
		Completed By												
		Lead hand / Supervisor Approval Verification												
		QC / QA Coordinator Approval												

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S128412
 Part: M6061T6B0.625X02.500
 Job No: 185813
 Serial No/Batch: M134553
 Revision:
 Inspector:
 Exp Date:
 Instructions: MATERIAL: 6061 - T6/T654/T65186T6511/T62 ALUMINUM BAR PER

Environment Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Operator Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Beginning Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : _____
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ORY Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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QA: _____ Date: _____



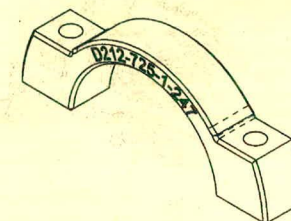
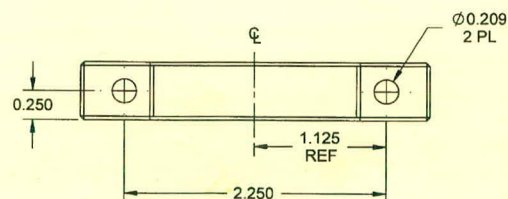
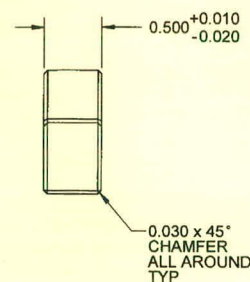
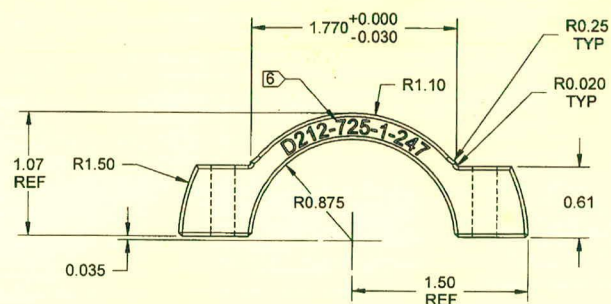
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

EAC
37
60



D212-725-1-247 RETAINER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
- 7) WEIGHT: 0.05 lbs

RELEASED
2011-08-25

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4163	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAM ASSEMBLY	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

